



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5735-041
Job Sheet 203329

Accounting Job RD19-1069-01



Part No: D5735-041

Job Qty: 1 pcs

Part Name: FWD Wearplate Assembly, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/15/19

Job Tracking No:

Due Date: 11/29/19

Created By: Marie Lajeunesse

Type: R+D

Description:

Note: URF 19-1206 DWG D5735 Rev.A IPP Rev. A 19.11.08 New issue DP Verify DD

Ship Via:

POSITIVE RECALL
EFFECTIVE 19/11/19 AUTH 60
DAS
RELEASED 9 DATE 19.11.03
989

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	1 pcs	11/29/19	11/29/19	0.00	0.80	Large Fab - 1		mf
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	1 pcs	11/29/19	11/29/19	0.00	0.00	QC 9 - 10		H
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1 pcs	11/29/19	11/29/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		



Container No: S236235



Part: D5735 - 041

Job No: 203329

Serial No/Batch: S236235

Revision: U/R Rev A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/29/19

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					QC 5 - 9	
					QC 5 - 50	CL
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	DAS
150	Spray Paint - 2 - B4B	1 pcs	11/29/19	0.00 0.17	Spray Paint - 1 - B4B	41 NOV 30 2019
					Spray Paint - 2 - B4B	9-89
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
160	QC 5	1 pcs	11/29/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	DAS
					QC 5 - 61	DEC 02 2019 40
					QC 5 - 81	9-89
170	Packaging 3-1 - Stock - B4B	1 pcs ✓	11/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B ✓	ST 471
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	

Oscar

DEC 04 2019

POSITIVE
RECALL

DAS

9

9-89

ok to release

					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180 QC 21 - SA	1 pcs	11/29/19	0.00 0.00	QC 21 - SA - 21	✓	ST 471
				QC 21 - SA - 70		DAS
				QC 21 - SA - 53		21 DEC 04 2019

Part Op 100 - 1- Weld D5736-041 to wearplate as per dwg D5735 304 S.S. Welding Rod BATCH #: M138585 2-
 Descriptions: Transfer drill holes in bar 3- Use DT to check fit after welding 4- ENSURE WELDED CLAMP FITS AROUND A
 3.62" DIAMETER WITH 0.375-0.500 THREAD EXPOSED WHEN SNUG.
 110 - QC9- Inspect visual per QSI004- Fusion Welds
 120 - QC5- Inspect part completeness to step on W/O
 150 - BATCH: 5227557 COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040
 THICK, PER DART QSI 005 4.9.
 160 - QC5- Inspect part completeness to step on W/O
 170 - Identify as per dwg & Stock Location:
 180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5617-1	Clamp	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	5225562
D5678-1	Hex Nut	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	5123782
D5735-1	FWD Wearplate	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	5035506
D5736-041	FWD Wearbar Assembly	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	5235129

Job Allocations

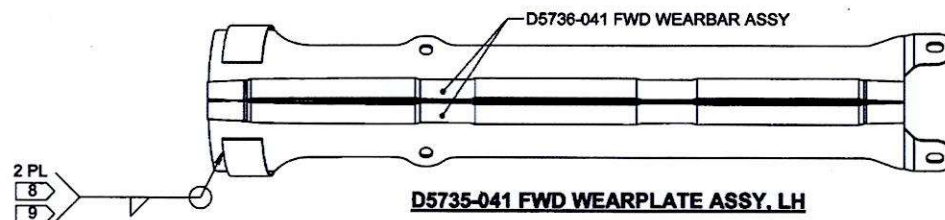
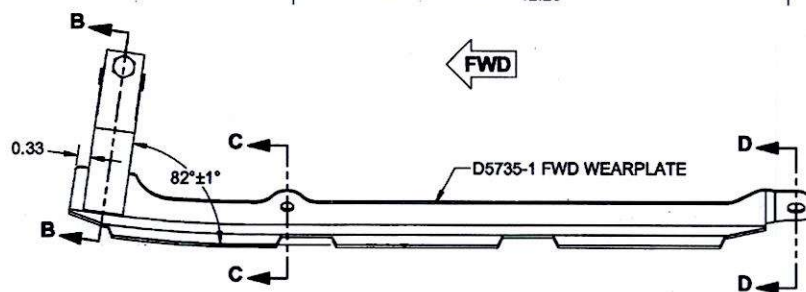
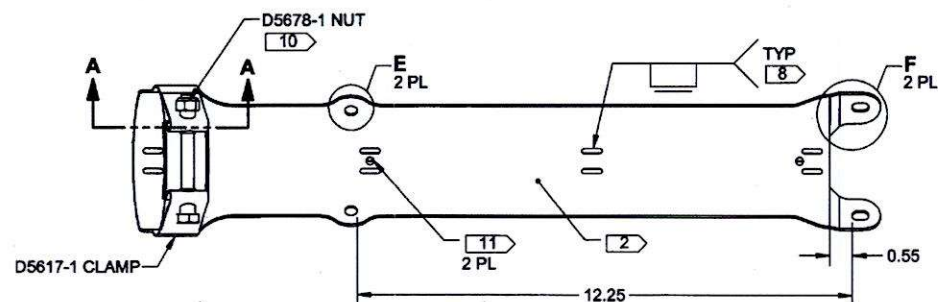
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D5617-1	1	16	0
	D5678-1	1	37	0
	D5735-1	1	0	0
	D5736-041	2	0	0

Part Specifications

Specifications could not be found.

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QTY -041	P/N	DESCRIPTION
X	D5735-041	FWD WEARPLATE ASSY, LH
1	D5735-1	FWD WEARPLATE
2	D5736-041	FWD WEARBAR ASSY
1	D5617-1	CLAMP
1	D5678-1	NUT



SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 203329 MW
19-11-18

UNDER REVIEW
URF 19-1206 19.11.07 (VM)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING PER DART QSI 005 4.9
MASK D5617-1 CLAMPS PRIOR TO FINISH.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5735-041" AND S/N PER DART QSI 044 6.1
- 7) WEIGHT: 3.38 lbs
- 8) WELD PER DART QSI 004
- 9) ENSURE WELDED CLAMP FITS AROUND A 3.62 DIAMETER WITH 0.375-0.500 THREADS EXPOSED WHEN SNUG
- 10) INSTALL HAND TIGHT ONLY
- 11) TRANSFER DRILL $\phi 0.188$ DRAIN HOLES FROM WEARPLATE THRU WEARBAR, OPEN HOLES TO $\phi 0.188$ AFTER FINISH IF REQUIRED

A	NEW ISSUE	ZF	19.08.20
REV.	DESCRIPTION	BY	DATE
DESIGN	ZF		
DRAWN	ZF		
CHECKED	MW		
MFG. APPR.	DD		
APPROVED	NO		
DE APPR.	DS		
DATE	19.08.20		

APPROVED

DART AEROSPACE USA, INC.
HILLSBORO, OR
DRAWING NO. D5735
REV. A
SHEET 1 OF 13
TITLE TRAINING WEARPLATES
SCALE NTS
COPYRIGHT © 2019 BY DART AEROSPACE USA, INC.
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>203329</u> Part No. <u>D3735-041</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☒ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐		
Date : <u>18.12.10</u>	Sequence #: <u>160</u>	QTY Affected : <u>1</u>		MRB (QSI042) <u>ND</u> 19.12.11 18.12.10
Description Work Order Deviation		Disposition		Completed By <u>ND</u> 19.12.11 18.12.10
angle 82° is outside tolerance is actually at 85°		Clamp will snug up against tube when torqued. Acceptable as is. Dwg will be amended to increase tolerance for manufacturability		Lead hand / Supervisor QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☒ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		
		Other/Details:		

